

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010764**Date Inspected:** 12-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed U-Rib dimensional survey along with QA inspector (Mr.Manjunath) for below segment. Reports forwarded to team leader for further action

6BE-6CE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6BE)**FCAW Process:**

Welding of weld joint -024 to 042 located on PCMK SP527-001, bottom panel T-Rib hold back area fillet weld. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (6CE)

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FCAW Process:

Welding of weld joint –036 to 049 located on PCMK SP528-001, Side panel T-Rib hold back area fillet weld. Welder is identified as 067942. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (5CW)

FCAW Process:

Welding of weld joint –001 located on PCMK SEG027F, Longitudinal flange to floor beam. Welder is identified as 220063. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Tc-U5-F.

OBG # TRIAL ASSEMBLY YARD (6CE)

SMAW Process:

Welding of weld joint –029 located on PCMK SP529-001, Side panel T-Rib. Welder is identified as 220063. ZPMC CWI is identified as Li Yang. Welding was been performed against Welding repair report: B-WR8988 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
